

Work Order ID 64768

Thursday, December 16, 2010 11:47:05 AM

Page 1

Item ID: D3637-3

Revision ID:

Item Name: Bracket

Start Date: 12/16/2010 Start Qty: 12.00

Required Date: 12/21/2010 Req'd Qty: 12.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10/24

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3637	Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 12-
Deburr if necessary

1810-12-16

18

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1810-12-16

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10/21/7

18

Work Order ID 64768

Thursday, December 16, 2010 11:47:05 AM



Page 2

Item ID: D3637-3

Revision ID:

Item Name: Bracket

Start Date: 12/16/2010 Start Qty: 12.00

Required Date: 12/21/2010 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3637	0.00 0.00		SP 10/01/04		(14)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub 10/01/04		(14)			
150 Small Fab Small Fab	Small Fab Memo 1- drill holes as per dwg using DT8979 2- c'sink holes as per dwg 3-deburr	0.00 0.00				(14X)			

= 7 m. 11/01/05

Work Order ID 64768

Thursday, December 16, 2010 11:47:05 AM



Page 3

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/16/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5.16/105

0.00

Memo

44

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

14 BR 11-01-5.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

= 7 11/01/05

14 Q

Work Order ID 64768

Thursday, December 16, 2010 11:47:05 AM



Page 4

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/16/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 246A

0.00

Memo

0.00

Li U 11/01/06 12

200



QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/01/06

MF 11-01-06

Picklist Print

Thursday, December 16, 2010 11:47:08 AM

Page 1

Work Order ID: 64768

Parent Item: D3637-3

Parent Item Name Bracket




Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV,B as per dwg 08-02-11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	94.8847	0.134	1.692632		2.5 12-16-10	

Location

Loc Qty

Loc Code

MAT22

94.8847

111381

11.89

113189

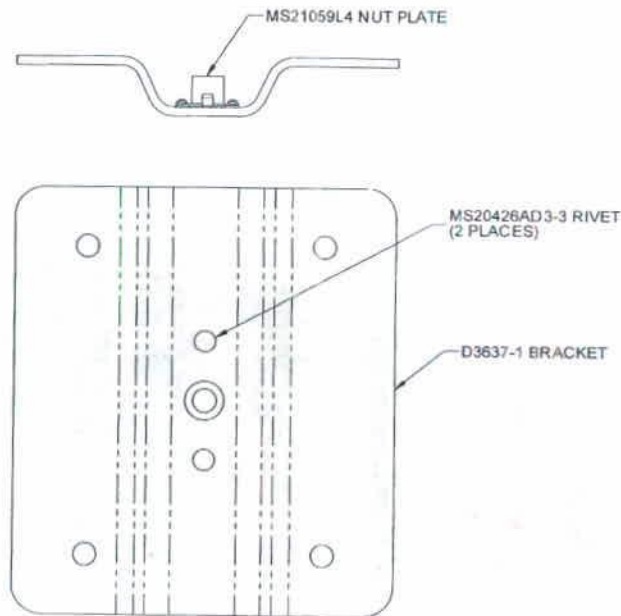
0.3947

114968

82.6

114968

18



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

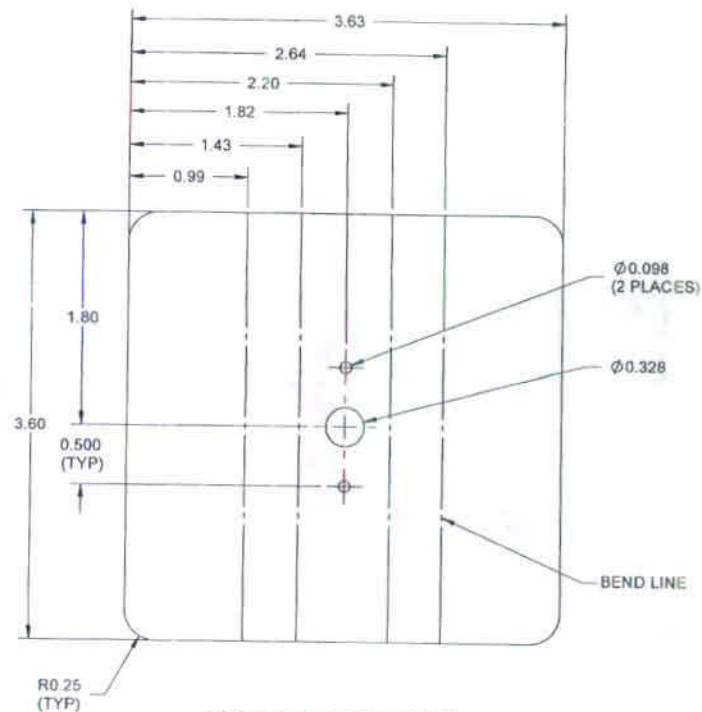
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61768*

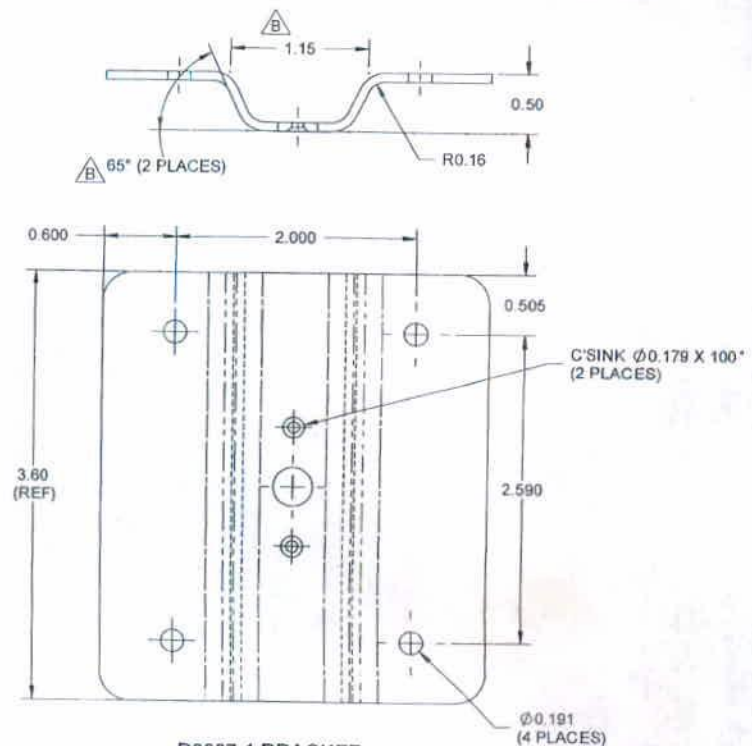
28 10-12-16

B	FOR D3637-1, 1 IS WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3637 TITLE BRACKET SCALE 1:1 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	
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MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	07.12.18		

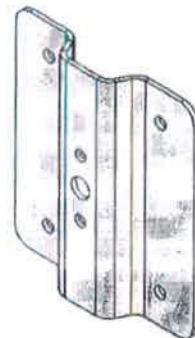
alou 4768



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)

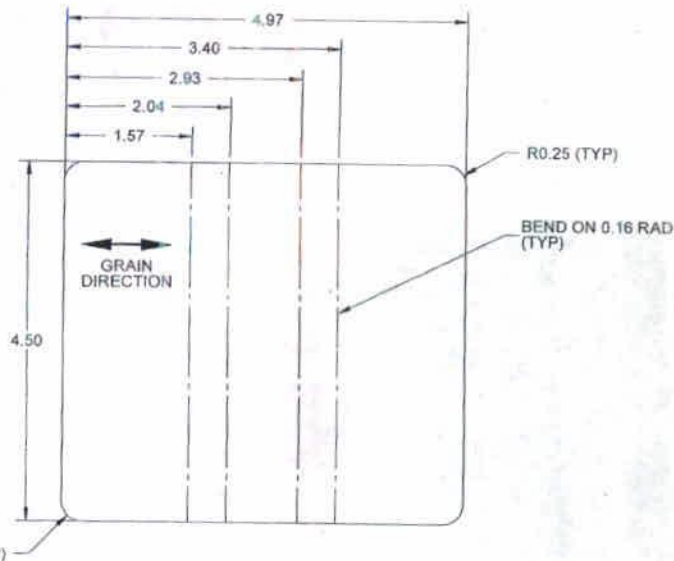


D3637-1 NOTES

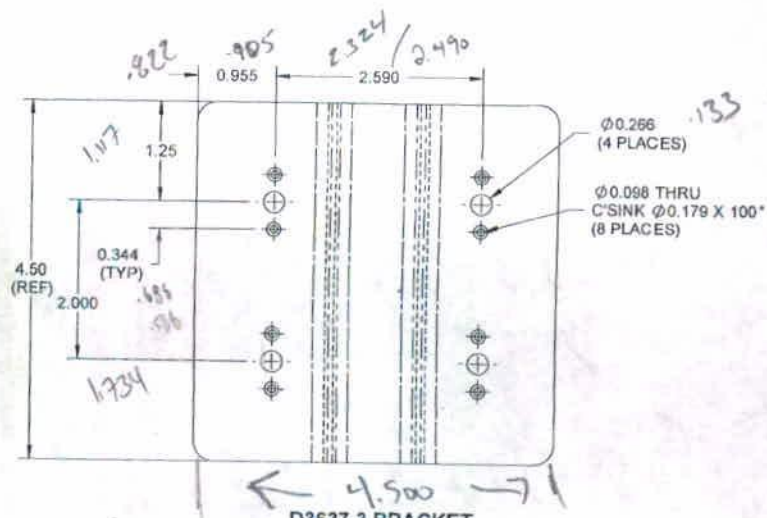
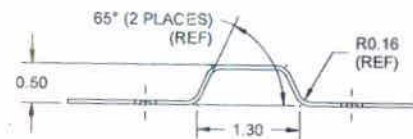
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

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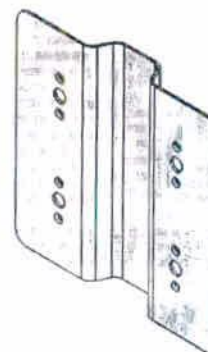
also 64768



D3637-3F FLAT PATTERN



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

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DE APPR.		BRACKET	2.3
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